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WELDING TUBE FOR HEAT EXCHANGER
AND ITS MANUFACTURE

Abstract:

PURPOSE: To improve the fitness of a welding tube and seat plate by bending both side parts of an Al made plate stock cladding a brazing filler metal about orthogonally, abutting the tip part to opposed wall faces and brazing it integrally.

CONSTITUTION: An Al made plate stock in long size is prepd, subjected to bending orthogonally in the same direction so as to form a wall face 22 as well and after joining tip parts 31, 31 a tip 32 is abutted to the opposed wall face 23. In this case, a weld zone 21 is formed at the inside of about center part of the wall faces 22, 23 and its tip 32 is integrally brazed with the weld zone 21 as well. This welding tube 20 is inserted into the fitting hole 26 of a seat plate 25 and then the defective brazing of a brazing filler metal at brazing time is prevented because of the outside seam part 27 of the weld zone 21 becoming almost on the same level. Due to the weld zone 21 abutting to the wall face 23 the recess to the inner side of the wall face 23 is not caused. Consequently the fitness of the tube 20 and seat plate hole 26 is improved.

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